

## AMENDMENTS TO THE SPECIFICATION

Please replace paragraph 40 with the following paragraph rewritten in amendment format:

As previously discussed, the present invention is not limited to the spiral shape; in alternate embodiments, other tool path algorithms keeping uniform exposure for varied shapes can be used. Also,  $V_{\max}$  can be decreased in various ways between successive layers to achieve a desired contour in a finished workpiece. The vertical cross section containing the axis of the hole determines how the  $V_{\max}(i)$  is progressed where  $i$  is the number of steps for reducing the  $V_{\max}$ . A linear function of  $V_{\max}(i + 1) = V_{\max}(i) - \Delta V_{\max}$  results in a constant taper with fixed taper angle. Another function of  $V_{\max}(i + 1) = V_{\max}(i) - (\Delta V_{\max} * i)$  makes the taper angle less and less steep as radius is reduced~~progressively steeper~~. On the other hand,  $V_{\max}(i + 1) = V_{\max}(i) - (\Delta V_{\max} / i)$  makes the taper angle progressively steeper~~less and less steep as radius is reduced~~. In general, the  $V_{\max}(i)$  needs to be determined by the cross section (or shape) specification.